



## Low Hydrogen Electrodes for Weathering Steel ALPHA 8018-W

### Characteristics:

**ALPHA 8018W** is an iron powder basic type electrode for all position welding. It shows high resistibility to atmospheric corrosion, since, its all weld contains Cu, Ni and Cr, Crack resistibility and mechanical properties are good. Smooth and regular fusion gives uniform bead shape. Welds are of radiographic quality. Typical Hydrogen Content and metal recovery in the weld metal are 3.82/100gms and 112.2% respectively.

### Applications:

Weathering steels like Corten A&B and equivalent grades, Medium tensile corrosion resistant structural steels, welding of high tensile steels.

### Typical Weld metal Composition

Element	Percent
C	0.060
Si	0.30
Mn	1.20
S	0.015
P	0.018
Cr	0.60
Ni	0.65
Cu	0.42

### Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm <sup>2</sup>	Yield Strength N/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Values at Minus 20°C. J
594	490	25	60 J

**Weld Metal Hydrogen Contents:** - < 4.0 ml/100 gram of weld metal deposit.

### Classifications:

<b>AWS/ A5.5:</b>	E 8018-W2
<b>BS 639:</b>	E 500Z B 32 (H5)

### Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC(70V) or DC (+)	Pieces per Packet	Pieces per Carton
5.00x450	190-2200	40	160
4.00x450	140-180	70	280
3.15x450	110-140	100	400
2.50x350	60-80	150	600

**Welding Instructions:-** Re-Dry the electrode at t 250° C to 300 °C for 02 hrs .

**Approvals :** RDSO AS PER IRS M-28/2017 CLASS D

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